

Date: Wednesday, 12/20/2006 1:47:32 PM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services <b>Job Number</b> : 30056 <b>Estimate Number</b> : 10008 <b>P.O. Number</b> : N/A <b>This Issue</b> : 12/20/2006 <b>S.O. No.</b> : N/A <b>Prsht Rev.</b> : NC <b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS <b>Previous Run</b> : 29811 <b>Written By</b> : _____ <b>Checked &amp; Approved By</b> : _____ <b>Comment</b> : Est Rev:I Removed from 9 Digit 05-10-25 JLM	<b>Drawing Name</b> : LUG  <b>Part Number</b> : D2591 <b>Drawing Number</b> : D2591 REV D <b>Project Number</b> : N/A <b>Drawing Revision</b> : D <b>Material</b> : N/A <b>Due Date</b> : 1/5/2007	<b>Qty:</b> 50 <b>Um:</b> Each
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### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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**Comment:** Qty.: 0.2340 f(s)/Unit    Total : 11.7000 f(s)

ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)

Batch: 17103069

inf 07/01/07

25

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 2.700" long

2nd 07/01/07

50

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

J.F. 07/01/29

50

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/01/29 / s.f 07/01/30 (50

5.0            QC8    SECOND CHECK



**Comment: SECOND CHECK**

MS 07/01/31

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *LD*   Date:   *7/10/05*  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:47:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 30056

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WEDINT

*Pa 7/22/01*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

*2007/02/05*

Job Completion



*U 07/02/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

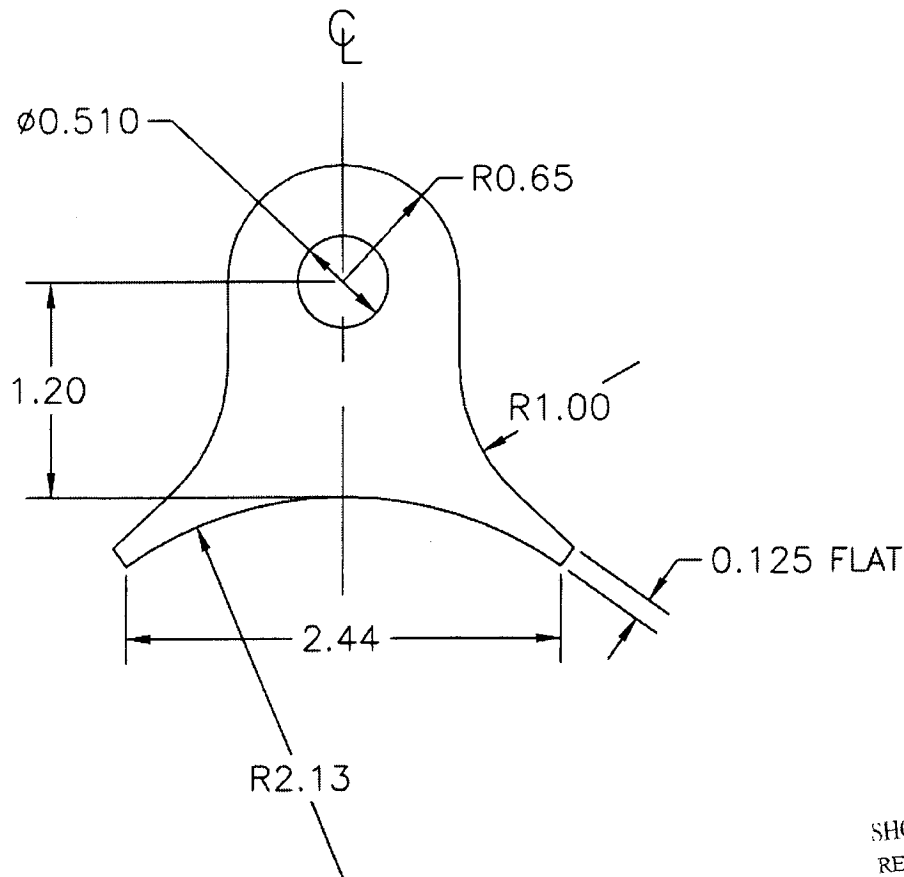
**NOTE:** Date & initial all entries





DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED  
98.01.21 DS



BREAK ALL SHARP CORNERS 0.010 TO 0.020  
MATERIAL: ASTM A36 STEEL 0.50 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30056